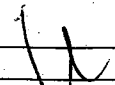
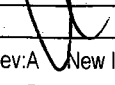


ASAP

Date: Thursday, 13/09/2007 8:37:29 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG BRACKET
Job Number : 34076B	
Estimate Number : 10339	
P.O. Number : N/A	Part Number : D2658
This Issue : 13/09/2007 / S.O. No. : N/A	Drawing Number : D2658 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 17/08/2007 Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 33780B	Material : N/A
Written By : 	Due Date : 20/09/2007 Qty: 30 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-08-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S12GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 0.1197 sf(s)/Unit Total : 3.5910 sf(s)
1010/1025/A21/6aA SHEET
12 GAUGE .100" THK
Batch: M104288 HB 07-09-17

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D2858
Dwg Rev: D HB 07-09-17
Prog Rev: D
2-Deburr if necessary HB 07-09-17

(30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 07-09-17

4.0	QC8	SECOND CHECK
-----	-----	--------------

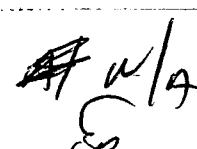


Comment: SECOND CHECK

HB 07/09/17 (X30) counter

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
1-Deburr as required. 

Date: Thursday, 13/09/2007 8:37:29 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 34076B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Bend on CNC brake using DT8254/Identify as D2658

SB 07/09/17 (30)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Gr A09/18 (30) cuts

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

107/09/18 (30)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/09/19 (30)

Job Completion

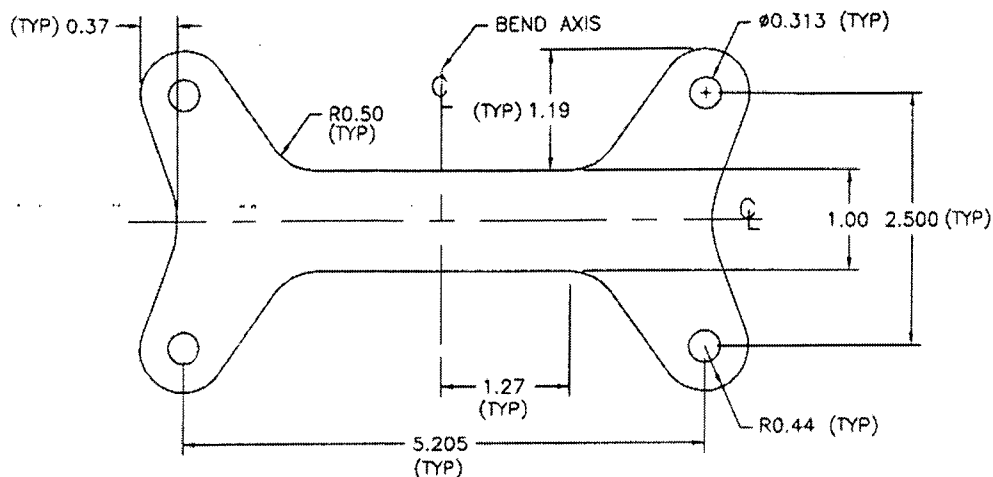


1107/09/18

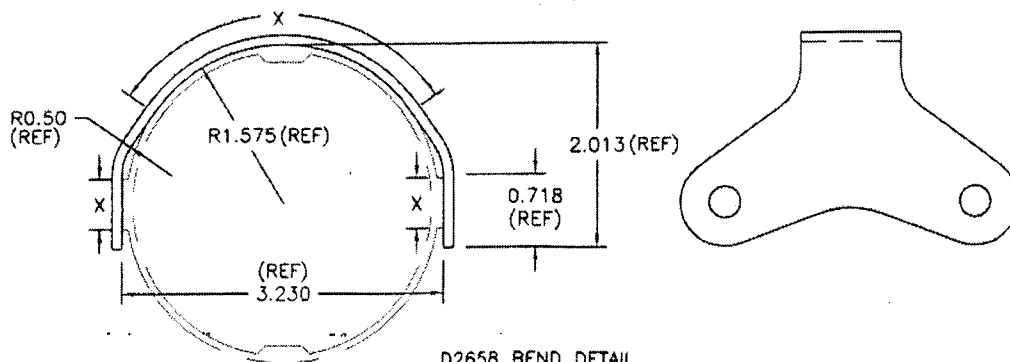


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

RELEASED
98.12.14 DS



D2658 FLAT PATTERN
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D2658 BEND DETAIL

D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

